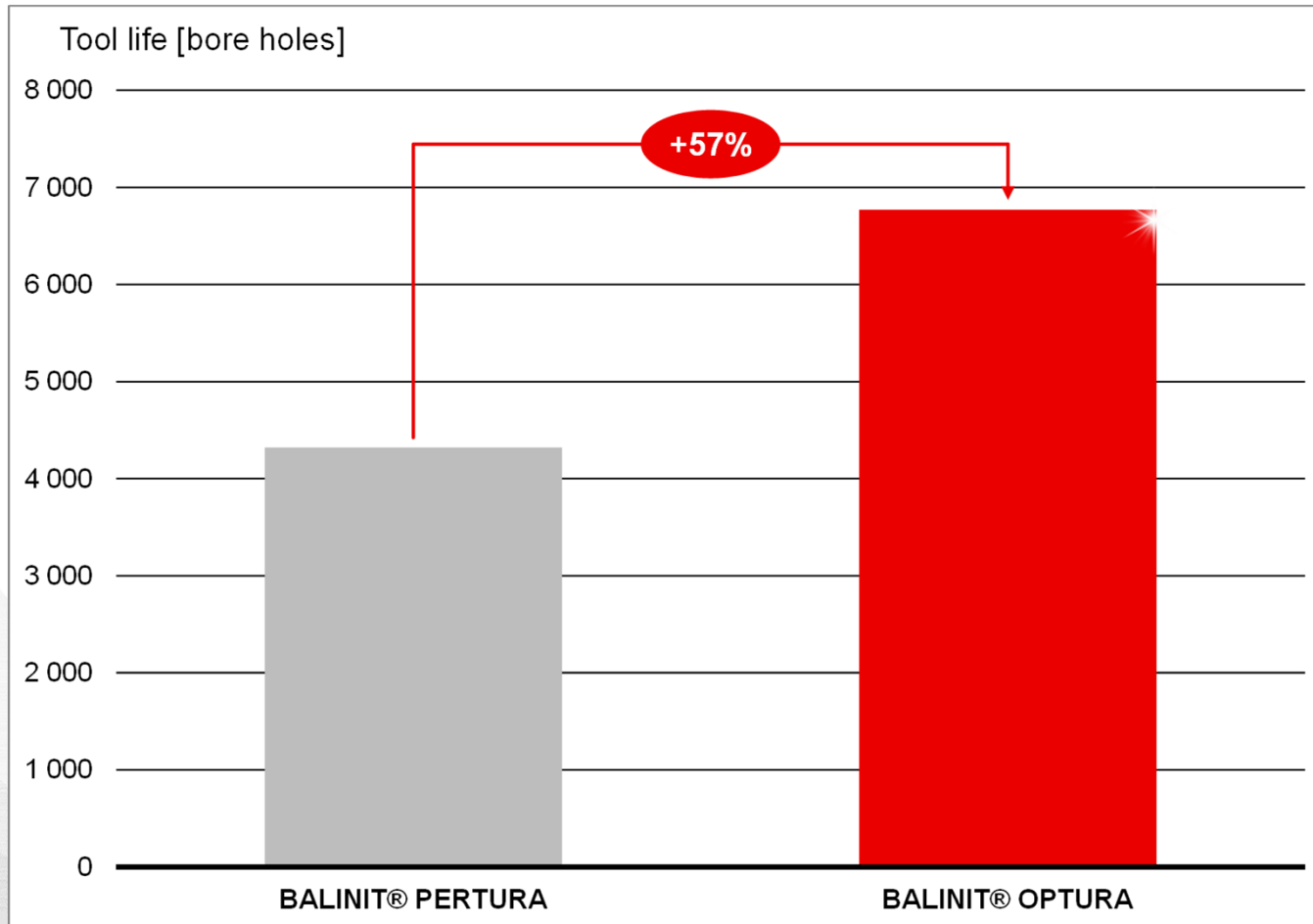


BALINIT OPTURA

Drilling of C35 / AISI 1035 / 1.0501

oerlikon



Tool:

Solid carbide step drill
D ≈ 10/14 mm

Workpiece:

Carbon steel AISI 1035 / C35 / 1.1191
(1.0501)
Drilling depth ≈ 28 mm

Cutting data:

$v_c = 120$ m/min
 $f = 0.35$ mm

Benefit:

Increase of tool life → decreased number of new tools / reconditioning-cycles → reduced costs per part

Source/Customer:

Tier 1 supplier
Automotive
Germany

oerlikon
balzers